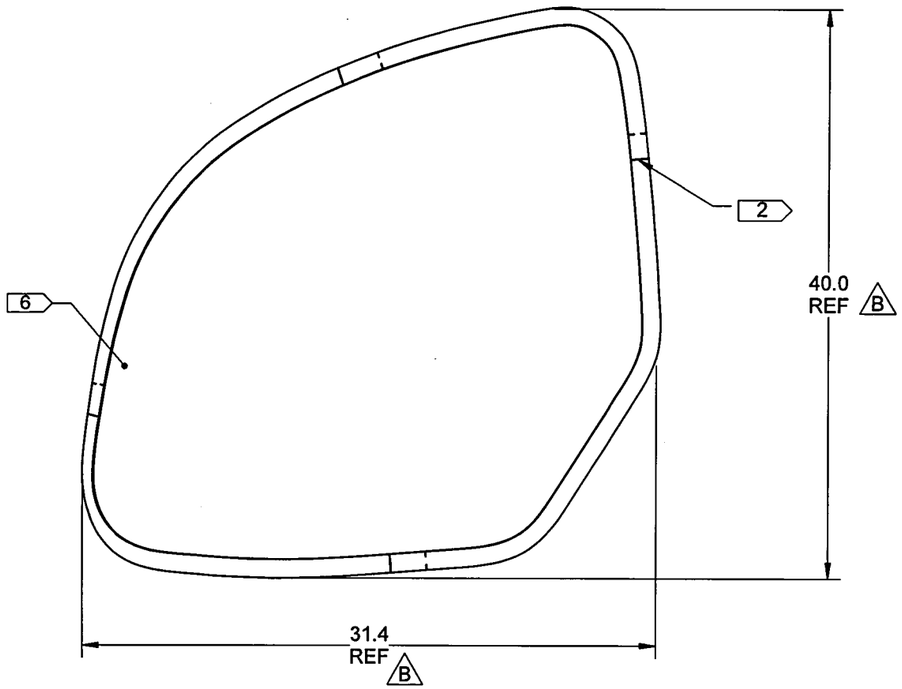

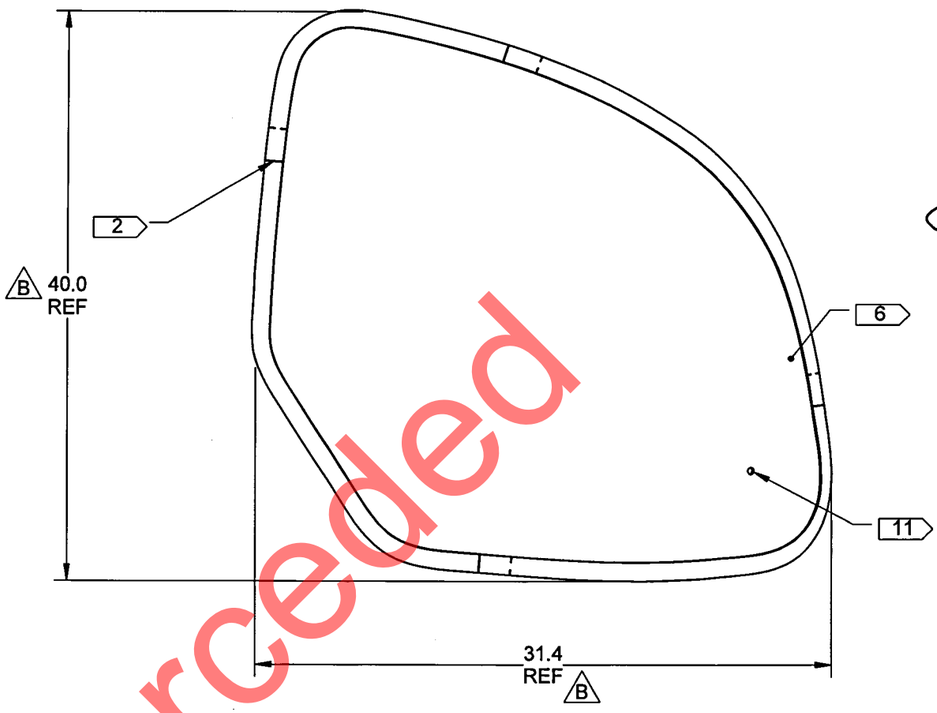

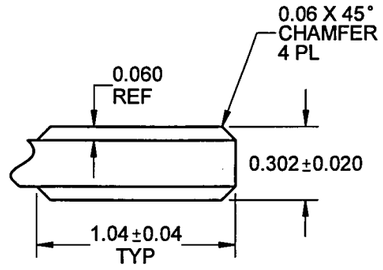

SECTION A-A

D5621-041/-043 SKYLIGHT WINDOW, LH

D5621-042/-044 SKYLIGHT WINDOW, RH

Superceded

RELEASED
2018 AUG 30
BN 18-791

NOTES:
1) MATERIAL: -041/-042: CLEAR UC MAKROLON, 0.177" THICK
-043/-044: POLYCARBONATE, FG, BRONZE #S109, 0.187" THICK
2) FINISH: APPLY LPI AEROCOAT 107P HARDCOAT (BOTH SIDES)
INSTALL LPI 9149 EDGE ATTACHMENT USING PR1425 PER "D5621-041 CF" (LH) OR "D5621-042 CF" (RH)
IT IS ACCEPTABLE TO SPLICE EDGE ATTACHMENT BETWEEN HOLES.
INNER AND OUTER SPLICES MUST BE AT LEAST ONE HOLE SPACING APART
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: ALL TRIMMED SURFACES MUST HAVE $\sqrt{}^{125}$ FINISH
6) IDENTIFICATION: SANDBLAST IDENTIFICATION USING 0.125" LETTERS IN LOCATION SHOWN (MAX 0.005" DEEP):
D5621-04X (P/N) SN XXX (S/N)
XX-20YY (DATE) 3AL64 (CAGE CODE)
7) WEIGHT: 6.40 - 7.25 LBS
8) FORM PER LPI PROCESS "D5621" USING LPI FORMING TOOL "D5621-041 FM" (LH) OR "D5621-042 FM" (RH) RESPECTIVELY
9) TRIM PER LPI TRIMMING TOOL "D5621-041 TF" (LH) OR "D5621-042 TF" (RH) RESPECTIVELY
10) EXTREME CARE MUST BE TAKEN NOT TO DAMAGE THE SURFACE OF THE WINDOW
11) DRILL ∅0.375 HOLE ON -042/-044 PER LPI TRIMMING TOOL "D5621-042 TF"
12) ACCEPTANCE CRITERIA:
A) MINIMUM THICKNESS AFTER FORMING IS 0.150"
B) CONTOUR: MUST FIT FORMING TOOLS WITH A MAX GAP OF 0.060" AT THE TRIM LINE WHEN
NO MORE THAN 4X 4 LB WEIGHTS ARE EQUALLY SPACED ON THE PERIMETER
C) DISTORTION: INSPECTOR TO VIEW THRU PART. NO MORE THAN 3X 0.060" DEFECTS IN A CIRCLE WITH A 6.77" RADIUS.
WINDOW MUST BE GENERALLY PARALLEL EXCEPT FOR WITHIN 1" OF THE WINDOW PERIMETER, WHICH IS NON-OPTICAL

REV.	DESCRIPTION	BY	DATE
B	ADDED 0.063" AROUND PERIMETER FOR INCREASED EDGE DISTANCE WHEN TRANSFER DRILLING	VS	18.07.25
A	NEW ISSUE	VS	18.02.21

APPROVED

DESIGN	DB
DRAWN	VS
CHECKED	RF
MFG. APPR.	RA
APPROVED	HS
DE APPR.	DS
DATE	18.07.25

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D5621 REV. B
SHEET 1 OF 1
TITLE SKYLIGHT WINDOW
SCALE NTS

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